

WYSONG & MILES

QUALITY REBUILT - WYSONG MODEL MTHII 400-168 HYDRAULIC PRESS BRAKE {7/16" x 14' Air Bending Capacity}

The Wysong Model MTHII 400-168 is a general purpose hydraulic press brake that was maintained, with yearly preventive maintenance schedules. Wysong acquired the 400-168 and disassembled the entire machine and inspected all components. This machine has been rebuilt and comes with a Limited Wysong Warranty.

EXCLUSIVE REBUILT FEATURES

Heavy duty construction for long-term, high production forming.

Careful mechanical and electrical diagnostics and inspection performed by experienced Wysong service engineers.

One-year parts warranty and 90 day labor warranty on machine only.

No warranty on the Automec or backgauge.

Under power and available for inspection.



U.S. Manufactured and Rebuilt at Wysong.

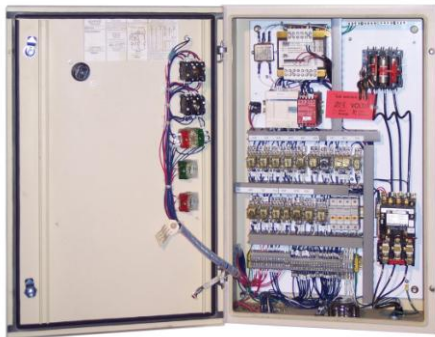
Under Power and Available for Inspection at our Facility.

The MTH 400-168 comes furnished with dual palm button station, remote electric footswitch, Automec CNC 300 control and a 48" range X-axis back gauge and 2nd axis ram control. The Automec system is not warranted, but reliable, expert service and trouble shooting is available from Automec. Automec also provides low cost, warranted, control updates.



**One Year Parts Warranty & 90 Day Complex Labor Warranty on machine only
No warranty on the Automec Controller or backgauge**

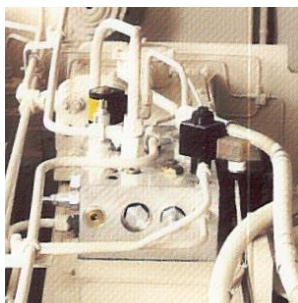
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DC Electrical Components included in NEMA 12 Enclosure.



Automec, 48" range X-axis back gauge is controlled through the Automec CNC300 control. Ram depth is also controlled through the Automec.



Hydraulic valves are incorporated into a monoblock manifold.

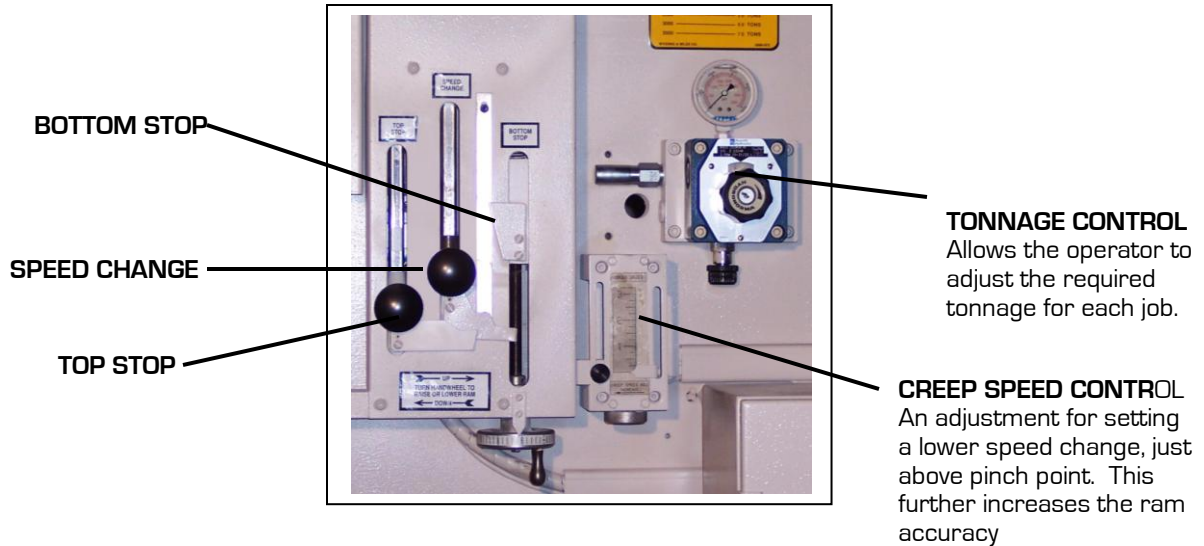


Bushings and bearings are included in the heavy seamless torque tube. The torque tube linkage includes split links and, zero clearance, Teflon bearings.

Construction Standards:

All Power press brakes comply with the construction standards of B11.3 Standards for Construction Care and Use of Power Press Brakes. ANSI B11.3 recognizes the user as being responsible for providing point of operation safeguarding. Appropriate safeguarding such as guards, pull backs or restraints can be easily attached to the machine.

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MTHII 400-168 Machine Specifications

Tonnage - Tons	400
Bending Length - inch	168"
Distance Between Housings - inch	150"
Open Height - inch	19"
Shut Height - inch	9"
Stroke Length - inch	10"
Throat Depth - inch	10"
Maximum Ram Tilt - inch	±1/4"
Approach Speed - inch/minute	250
Press Speed - inch/minute	16
Return Speed - inch/minute	200
Ram Repeatability in Pressing Speed (with Creep Speed Setting)	±.002"
Overall Length - inch	180"
Overall Width - inch	80"
Overall Height - inch	128"
Bed Height - inch	38"
Bed Top Width	12"
Bed Projection Below Floor - inch	0"
Motor Horsepower	25
Oil Reservoir Capacity - Gallons	118
Estimated Shipping Weight - Lbs.	58,200

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WYSONG Model MTHII 400-168 HYDRAULIC PRESS BRAKE

Construction Features

Frame:

- Welded steel construction with contoured stress points.
- Narrow hydraulic tank welded between the side frames. In the upper section, and shaped to eliminate any interference in the work area.
- Cylinder mounting plate is machined with a shoulder to provide a positive location for the cylinder. This ensures that the mounting bolts are never in a shear condition when the machine is under load. The mounting plate weldments are engineered to withstand a shear load equal to six times the maximum tonnage rating of the machine.

Ram:

- Solid, one-piece steel construction.
- Ram furnished with dual non-metallic ram gibbing on each end.
- Precision roller guides for lateral stability.
- The large torque tube stabilizes both ends of the ram to ensure ram parallelism and allows for tilt adjustments.
- One-shot oil lubrication.
- Adjustable ram tilt to $\pm 1/4$ ".
- Spherical bearing connection between the ram and the piston rods for ram tilting without lateral stress on the piston rods.
- Ram brace maintains a ram straightness to $\pm .001$ " per foot along the length of the ram.
- Spring loaded ram clamp bars.
- 100 ton through 400 ton press brakes are furnished with replaceable threaded inserts in the ram for the clamping bar screws.

Bed:

- Steel plate construction.
- Smooth bed top with die holder clamp bars.

Hydraulics:

- Filled reservoir with multipurpose, automatic transmission fluid.
- Hydraulic valves are incorporated into a single monoblock manifold for reduced tubing and connections.
- High pressure, aircraft quality steel tubing in place of rubber or plastic hoses.
- 10 micron return filters with service indicator.
- Manual tonnage control.
- Low speed control valve to ensure $\pm .002$ " ram repeatability for air bending and to prevent sheet whip-up of long flanges.
- Hydraulic flow divider.

Y1-Y2 Cylinders:

- Cylinders are machined from high quality steel forgings.
- Monoblock cylinders construction minimizes seal interfaces, wear points and load concentration.
- Pistons are precision finished and induction hardened.
- Non-metallic bearing ensure proper guidance in the cylinder bore, eliminating piston and bore contact.
- High pressure seals are used at the piston and rod cap.

Motors Controls:

- Electric motor controls with fused disconnect switch, low voltage control circuits in NEMA 12 enclosure.
- PLC simulates relay logic and reduces the amount of electrical circuitry to ensure easier servicing and trouble shooting.
- Key lock selector switches.
- Power "On" and motor "Run" light.
- Pedestal mounted, dual palm button station, including emergency "Stop" and "Up" button.
- Remote, electrical footswitch.

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